



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D4634-145
Job Sheet 167078-I



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft. Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 17-12-19
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 17-12-20
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	PD 17-12-20
140	QC Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-20
	Part Op 140	1 Ea		11/10/17	0.00	0.00	QC21	

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 J022398	1 J022398	3	0	0
	D4636-5 F16J358	1	43	0	0
	D4647-1 J022398	1	4	0	0
	D4664-5 J022398	6	39	0	0
	D4712-1 J022398	1	4	0	0
	D4732-17 J022389	1	0	0	0
	D4732-23 J022387	1	1	0	0
	D4732-27 J022386	1	1	0	0
	D5021-5 J022385	1	1	0	0
	MPNY-750S-9-C J022382	9	570	0	0
	MS20426AD3-4 J022381	4	5,055	0	0
	MS20426AD4-6 J022380	2	2,797	0	0
	MS21059L08 J022379	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-COMFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thmoforming ☐ Cross tube ☐ Small Fab ☐	Water Jet ☐ Prod Eng. Coord. ☐ Packaging ☐ Supplier ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																								
Date : _____	Step #: _____	MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																									
 S022945 Aft, Center Ceiling Replacement Panel Assembly D4634-145 Start up Operation Mfg Date: 12/15/17 Job No: 167078-1																																											
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>	Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	PART NO: Revision: Operation: Change No: <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Broken/Damage/Defect ☐</td><td style="width:50%;">Grain ☐</td></tr> <tr><td>Inspection Incomplete/Unqualified ☐</td><td>Weld ☐</td></tr> <tr><td>Contamination ☐</td><td>Wrong Stock Pulled ☐</td></tr> <tr><td>Countersink ☐</td><td>Out of Sequence ☐</td></tr> <tr><td>Cut Too Short ☐</td><td>Off-set ☐</td></tr> <tr><td>Instructions Incomplete/Unclear ☐</td><td>Mislabeled ☐</td></tr> <tr><td>Drill Holes ☐</td><td>Fit/Function ☐</td></tr> <tr><td></td><td>Misaligned/off center ☐</td></tr> </table>			Broken/Damage/Defect ☐	Grain ☐	Inspection Incomplete/Unqualified ☐	Weld ☐	Contamination ☐	Wrong Stock Pulled ☐	Countersink ☐	Out of Sequence ☐	Cut Too Short ☐	Off-set ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐	Drill Holes ☐	Fit/Function ☐		Misaligned/off center ☐
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